

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026253**Date Inspected:** 01-Sep-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** As noted below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. 3E PP20 Pipe Support Bracket (Exterior)
2. 3W PP20 Pipe Support Bracket (Exterior)
3. Crossbeam #4 Service Platform 5 (Exterior)
4. 11W 12W Side Plate C (Exterior)
5. 9E PP76 E4 Lifting Lug Holes (Interior)

1. 3E PP20 Pipe Support Bracket (Exterior)

The QA inspector observed F.W. Spencer welder Curtis Jump ID# 7326 performing Shielded Metal Arc Welding (SMAW) in the 2F horizontal position on 2.5 and 4 inch pipe support bracket located at 3E PP20 weld #110901-01. The QA inspector verified the fit up of the joints and found it to be satisfactory. The QA inspector observed the QC inspector identified as Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-FWS Fillets Murex SFOBB Rev. 1. The welder was observed implementing E7018-H4R electrodes and the QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appeared to be in general conformance with the contract documents.

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### 2. 3W PP20 Pipe Support Bracket (Exterior)

The QA inspector observed F.W. Spencer welder Curtis Jump ID# 7326 performing SMAW in the 2F horizontal position on 2.5 and 4 inch pipe support bracket located at 3W PP20 weld #110901-02. The QA inspector verified the fit up of the joints and found it to be satisfactory. The QA inspector observed the QC inspector identified as Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-FWS Fillets Murex SFOBB Rev. 1. The welder was observed implementing E7018-H4R electrodes and the QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appeared to be in general conformance with the contract documents.

### 3. Crossbeam #4 Service Platform 5 (Exterior)

The QA inspector observed ABF welder Rick Clayborn ID# 2773 perform Flux Core Arc Welding (FCAW) in the 2F horizontal position on the service platform stair attachment tabs on stair 1 on crossover beam #4. The QA inspector observed the QC inspector identified as William Sherwood monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS- F2200-3 and RFI# ABF-RFI-002417R00. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appeared to be in general conformance with the contract documents.

### 4. 11W 12W Side Plate C (Exterior)

The QA inspector randomly observed ABF welding operator Jin Pei Wang ID#7299 performing Flux Core Arc Welding with gas (FCAW-G) utilizing a "Bug-O" motorized rail system with a magnetic base attached in the 4G overhead position on the underside of side plate C, at 11W 12W of the OBG. The QA inspector observed the QC inspector identified as Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-3042B-1. The parameters were recorded as (A=250/V=24/TS=175/HI=2.05). The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appears to be in general conformance to the contract requirements.

### 5. 9E PP76 E4 Lifting Lug Holes (Interior)

The QA inspector observed the QC inspector identified as Fred Von Hoff perform Magnetic Particle Testing on the completed welds on lifting Lug Hole #1 and 3 at 9E PP76 E4 on the interior of the OBG. The QA inspector verified that the proper procedure was utilized as well as correct technique. The testing found no indications and the QA inspector verified the findings and noted that the work appeared to be in general conformance with the contract documents.

#### **Summary of Conversations:**

At the beginning the shift the QA inspector met with QC inspector William Sherwood and discussed the welders assignments and locations for the shift to include pending issues, ongoing work and required testing.

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Frey,Doug	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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